

Hex 100

Galaxy 2S can drop it!!

Work Order ID ~~76187~~***76187***

Page 1

November-07-11 1:25:52 PM

Item ID: D2806-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 07/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/11/08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2806	Rev A								
100	DOOSAN LATHE	0.00				12	0		
100									
Doosan	Memo	0.00							
Doosan Lathe	1- Turn as per Folio FA105 Rev: <u>1</u> & Dwg D2806 Rev: <u>1</u> 2-Deburr per dwg D2806								
			SA	11/12/20					
110	QC2- Inspect parts off machine FAI/FAIB	0.00				12	0		
110									
QC	Memo	0.00							
Quality Control			SA	11/12/20					
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control			SA	11/12/20		12	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November-07-11 1:25:52 PM

Item ID: D2806-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bushing

Stop *NS2*

Start Date: 07/11/2011 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 21/11/2011 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

Memo

0.00

HandFinish

Hand Finishing

140

QC3- Inspect Part Finish

0.00

140

Memo

0.00

QC

Quality Control

150

Identify as per dwg & Stock Location 22

0.00

150

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76187

76187


Page 3

November-07-11 1:25:52 PM

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/12/22 
 MF 11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-07-11 1:25:57 PM

Page 1

Work Order ID: 76187

76187

Parent Item: D2806-3

D2806-3

Parent Item Name: Bushing

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B05.03.11Part now turned KJ/JLM
IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6H1.000

Purchased

No

110

f

19.9880

0.0916

1.157053

M6061T6H1 000

**

5/11/12/14

6061-T6 HexBar 1.00

Location

Loc Qty

Loc Code

MAT012

19.988

109478

1.721

116623

5.797

119275

12.47

1.247

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76187
Description: Bushing		Part Number:	D2806-3
Inspection Dwg: D2806 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.003	/			
1.155	+/-0.010	1.150	/			
0.250	+/-0.010	.250	/			
0.063 x 45°	+/-0.010	.063 x 45°	/			
0.080 x 45°	+/-0.010	.080 x 45°	/			
0.495	+0.000/-0.005	.493	/			
0.750	+0.000/-0.005	.747	/			
Ø0.316	+0.005/-0.000	Ø.312	/			
0.094	+/-0.005	.094	/			

Measured by:	SA	Audited by:	anf	Prototype Approval:	N/A
Date:	11/12/20	Date:	11/12/20	Date:	N/A

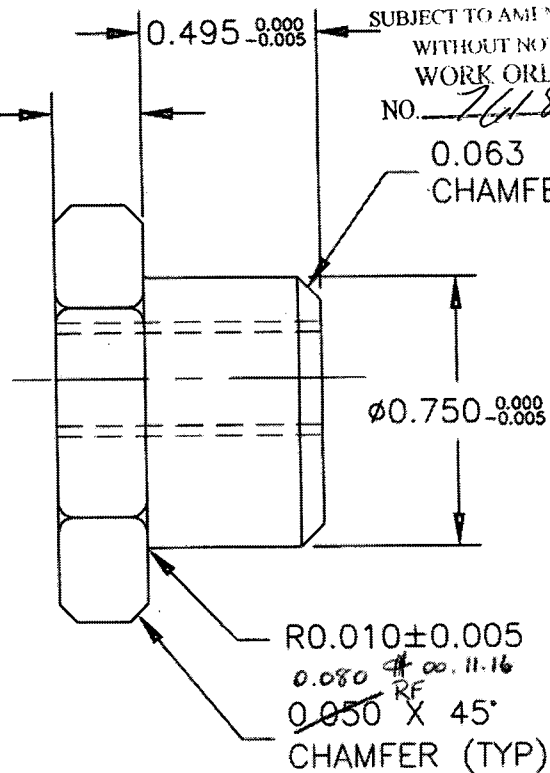
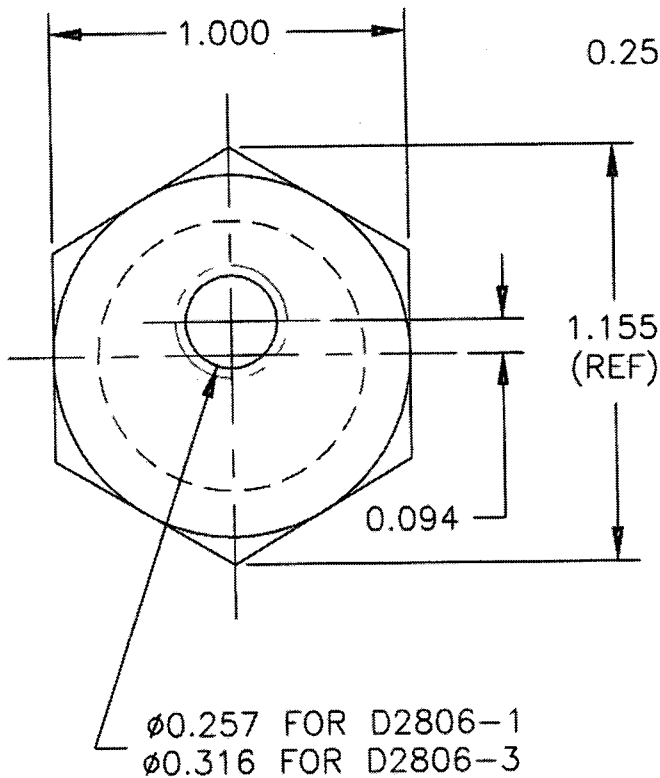
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.11.27	0.094 dimension added	KJ/EC	



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 #

11-11-08 SHOP COPY
RETURN TO
ENGINEER NO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76187
0.063 x 45°
CHAMFER



D2806-1 (DRILL Ø0.257 HOLE)
D2806-3 (DRILL Ø0.316 HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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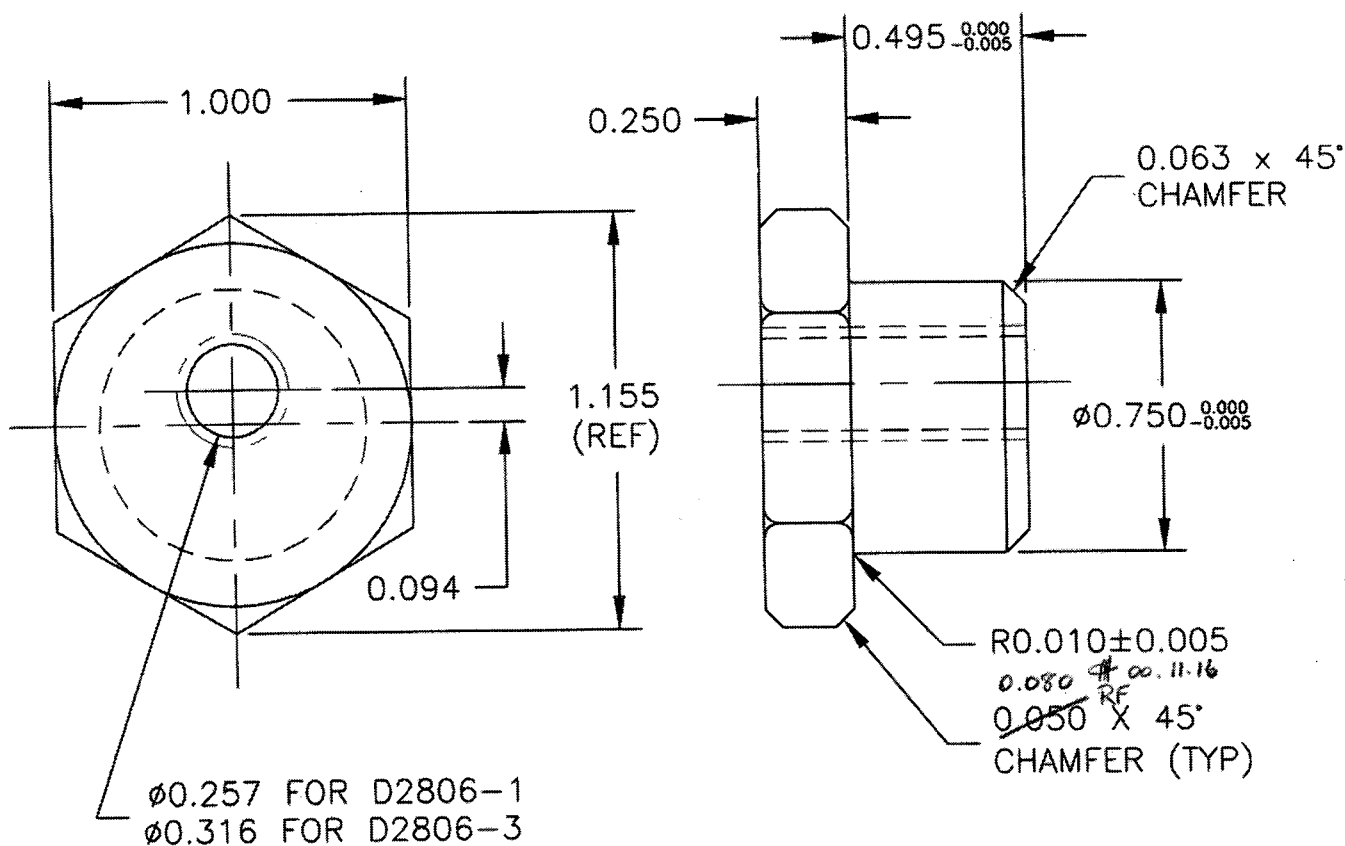
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 #

76107



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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